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D3278-3

Job Sheet 201658



153
DAS
21
9-39

Part No: D3278-3

Job Qty: 160 pcs

Part Name: Spacer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/8/19

Job Tracking No:

Due Date: 10/31/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP . A 04.04.19 New issue KJ/JLM IPP B 07.09.06 Rev C dwg EC Verified by: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
100	Waterjet - Flow - 1	160 pcs	10/31/19	10/31/19	0.01	3.11	Waterjet - Flow	19/10/21
120	QC 8	160 pcs	10/31/19	10/31/19	0.00	0.00	QC 8 - 12	
							QC 8 - 14	
							QC 8 - 17	
							QC 8 - 20	
							QC 8 - 25	
							QC 8 - 3	
							QC 8 - 32	
							QC 8 - 33	
							QC 8 - 35	
							QC 8 - 39	
							QC 8 - 4	
							QC 8 - 44	
							QC 8 - 45	
							QC 8 - 49	
							QC 8 - 58	
							QC 8 - 8	
							QC 8 - 9	
							QC 8 - 68	
							QC 8 - 67	
							QC 8 - 1 (A)	
							QC 8 - 47	
							QC 8 - 40	
							QC 8 - 52	
							QC 8 - 23	
							QC 8 - 57	
							QC 8 - 76	
							QC 8 - 61	
130	Small Fab - 2 - B4B	160 pcs	10/31/19	10/31/19	0.00	2.82	Small Fab - 1 - B4B	
							Small Fab - 2 - B4B	
							Small Fab - 3 - B4B	

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140 QC 5	160 pcs	10/31/19	0.00 0.00	Small Fab - 4 - B4B	OCT 23 2019
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	AP / Michel D / 22/19
				Small Fab - 8 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
150 Packaging 3-1 - Stock - B4B	160 pcs	10/31/19	0.00 0.00	QC 5 - 40	OCT 23 2019 DAS 40
				QC 5 - 61	9-89
				QC 5 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PZ GA117
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	

160 QC 21 - SA		160 pcs	10/31/19	0.00 0.00	Packaging 3 - 36 - B4B	
					QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9-59
Part Op 120 - (QC8- Inspect parts - second check) Descriptions: 130 - (Small Fab) 140 - (QC5- Inspect part completeness to step on W/O) 150 - Identify as per dwg & Stock Location: _____ 160 - (QC21- Final Inspection - Work Order Release)						OCT 24 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MDELRINS0.125	Black Delrin Sheet .125	5.5040 sf (.0344 ea)	100-Waterjet - Flow - 1	FM138295

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	MDELRINS0.125	6	34	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	1.980inches ± 0.030	2.010 1.950		
2	Spacer	1.980inches ± 0.030	2.010 1.950		
3	Spacer	1.480inches ± 0.005	1.485 1.475		
4	Spacer	0.250inches ± 0.010	0.260 0.240		
5	Spacer	1.480inches ± 0.005	1.485 1.475		
6	Spacer	0.250inches ± 0.010	0.260 0.240		
7	Spacer	0.098inches + 0.005 - 0.000	0.103 0.098		
8	Spacer	0.130inches ± 0.030	0.160 0.100		
9	Spacer	0.125inches ± 0.010	0.135 0.115		

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>201658</u>		DISPOSITION		DEPARTMENT/PROCESS				MRB (QS1042)			
Part No. <u>D3278-3</u>		Rework ☒ Scrap ☒ Use-as-is ☐		Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☒ Supplier ☐ Quality ☐	
Date: <u>NOV 23 2019</u>	Sequence #: <u>120</u>	QTY Affected: <u>13 of 166</u>		Disposition							
Description Work Order Deviation				Disposition							
<u>Hole was off center due to sheet moving while cutting</u>				<u>Scrap no replace</u>							
Root Cause				FAULT CATEGORY							
☐ Operator				☐ Contamination				☐ Power Loss/ Surge			
☒ Manufacturing Process				☒ Misaligned/off center				☐ Folio/Program			
☐ Equip/Tooling				☐ BOM/Route				☐ Grain Direction			
☐ Handling/Preservation				☐ Broken/Damage/Defect				☐ Weld			
☐ Material				☐ Incomplete/Unclear Instructions				☐ Wrong Stock Pulled			
☐ Product Improvement				☐ Drill Holes				☐ Out of Sequence			
☐ Process Improvement				☐ Fit/Function				☐ Off-set/Set-up			
☐ Human Factors				Other/Details: <u>one hole was off center</u>				☐ Positioned Wrong			
								☐ Outside Tolerance			
								☐ Drawing			
								☐ Finish			
								☐ Part Lost/Missing			
								☐ Misread			

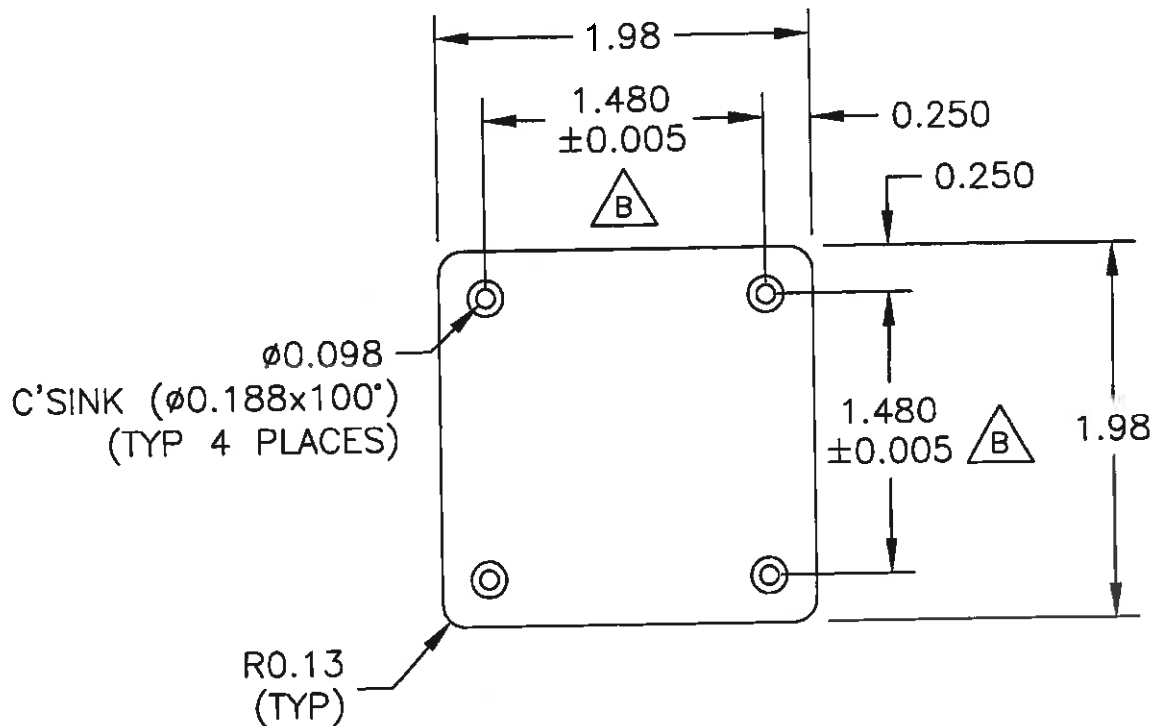
Completed By DAS
40
NOV 23 2019
9:00

Lead hand / Supervisor

QC / QA Coordinator

DART

DESIGN <i>GP</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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